

## Rakoll<sup>®</sup>surepress

### with Surepress MP Crosslinker

- Type of Product** Polyurethane dispersion adhesive for membrane press.
- Product Characteristics**
- good adhesion properties on plastic foils
  - mixed with Surepress MP Crosslinker, it achieves higher heat resistance
  - the mixture can be readily sprayed and provides a good and even coating
  - Surepress MP Crosslink is a solvent-free liquid isocyanate which mixes easily with the adhesive
- Typical Applications** Bonding of thermoplastic laminates on shaped parts in membrane presses.
- Suitable substrates** PVC, ABS, PET foils, wooden boards, etc.  
Proper tests should be made in advance to determine if the materials can be bonded with this adhesive.

### Typical Properties

Property	Value
Base	PUR Dispersion
pH	approx. 7
Viscosity (Brookfield RV, Sp3, 20rpm, at 20°C)	approx. 1 900 mPa.s
Shelf life	6 months

**Application Instructions****Preparation:**

Rakoll®surepress and Surepress MP Crosslinker must be mixed together homogeneously so that the finest possible distribution is achieved. For this purpose, the components should be mixed using motor-driven agitating paddles. The hardener is added to the agitated adhesive.

**Mixing ratio:**

- 100 parts by weight Rakoll®surepress
- +5 parts by weight Surepress MP Crosslinker

**Pot-life:**

- 8 – 10 hours at approx. +20°C.
- (Pot-life depends on ambient temperature)

**Application method:**

The adhesives mixture is best applied using HVLP (High Volume Low Pressure) spray guns, nozzle diameter 1,0 – 1,8 mm.

The quantity to be applied depends on the type of material and the shape of the parts. It can vary within a wide range and can only be determined by trials for a given set of variables. As a rough guideline, it can be assumed:

- 50 – 60 g/m<sup>2</sup> on the machined surface
- 20 – 40 g/m<sup>2</sup> on the non-machined surface

**Drying:**

The adhesive should be allowed to dry completely. The required drying time is affected by external factors, such as room climate, quantity applied, absorbency of the material, etc. For normal temperatures, 20 minutes to one hour can be assumed. Heat and/or air motion reduce the drying time.

**Press conditions:**

The pressing conditions depend on factors such as the thickness of the laminate (and its stiffness), the shape of the part to be coated, etc. They must be adapted to the situation.

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**Application Instructions****Starting values for trials:**

Membrane temperature: 80°C – 120°C

(Not identical with the temperature setting of the press!)

Recommended activation temperature in the glue line: minimum 62°C

Press pressure: 3 – 4 bar

Pressing time: 80 – 120 seconds

The initial strength is adequate for careful processing.

However, final strength of the bond is achieved after minimum 72 hours if the bonded parts were stored at standard ambient temperature.

**Heat resistance:**

The final heat resistance of the manufactured pieces depends amongst other factors on the glued materials and the shape of the profiles. No general statement can therefore be made regarding the heat resistance. Typical values reached approx. 90°C for 1 hour.

**Cleaning Instructions**

Clean application tools with water before the adhesive dries.

**Typical Packaging**

Please contact your local Sales Office for available packaging options.

**Storage Conditions**

In original sealed packaging protected from sun, dust, moisture and high temperatures in clean and dry conditions between 5°C and 35°C. Protect from frost.

**Disposal Advice**

Please refer to the MSDS for disposal instructions.

**Safety Advice**

Please refer to the MSDS for safety advice.

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